

Date: Tuesday, 9/4/2007 11:30:15 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: HEAT OUTLET DEFLECTOR
Job Number	: 34415		
Estimate Number	: 12154		
P.O. Number	: N/A	Part Number	: D34721
This Issue	: 9/4/2007	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D3472 REV.A
First Issue	: N/A	Project Number	: N/A
Previous Run	: 32134	Drawing Revision	: A
	Type : PURCHASED PARTS	Material	: N/A
Written By	: <u>[Signature]</u>	Due Date	: 10/4/2007
Checked & Approved By	: <u>[Signature]</u>	Qty:	6 Um: Each
Comment	: est rev. A 06.02.02 new issue EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
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1.0	M2024T3S040	2024-T3 .040 sheet
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Comment: Qty.: 0.0573 sf(s)/Unit Total : 0.3440 sf(s)  
 2024-T3 .040 sheet  
 Batch: M103321

SAD 07/09/09

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET  
 Cut as per Dwg D3472  
 Dwg Rev: A  
 Prog Rev: A

SAD 07/09/09

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 07/09/09

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

Er 07/09/10 (26)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1  
 1- Deburr

SAD 07/09/11 (6)

2-Bend as per dwg D3472

SAD 07/09/12 56

3- Buff-out any marks due to bending

FF 07/09/25

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: D Date: 01/05/20  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 9/4/2007 11:30:15 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HEAT OUTLET DEFLECTOR

Job Number: 34415

Part Number: D34721

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 07/09/25

(6)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FF 07/09/25

6

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SAD 07-09-25

(6)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

FF 07/09/25

6

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/09/26

(6)

Job Completion



07/09/26

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

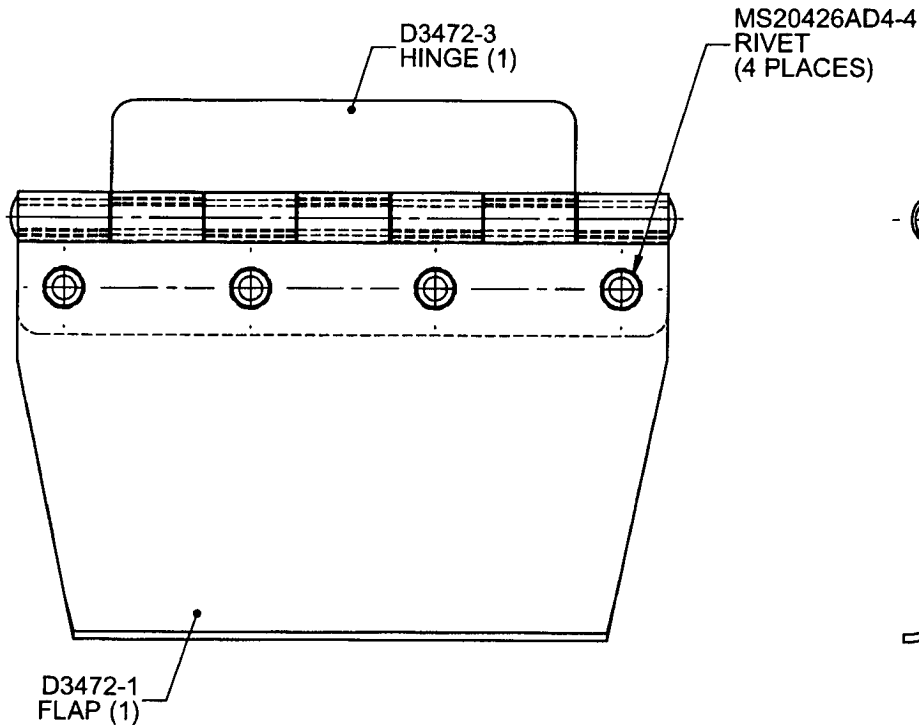
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3472</b>	REV. A SHEET 1 OF 4
DATE <b>06.01.17</b>		TITLE <b>HEAT OUTLET DEFLECTOR</b>	SCALE 1:1
A	06.01.17	NEW ISSUE	

06.04.03 *[Signature]***D3472-041 CABIN HEAT OUTLET DEFLECTOR**

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WITHOUT NOTICE  
WORK ORDER  
NO. *34415*

**NOTES:**

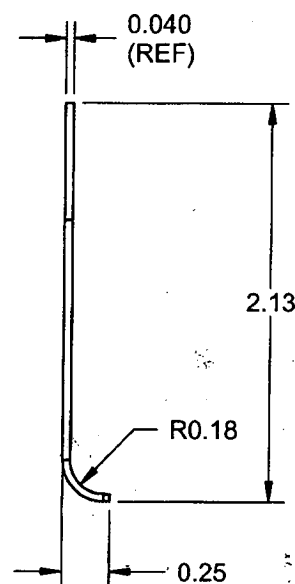
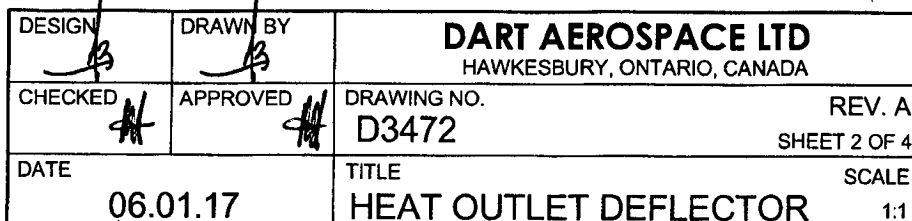
- 1) IDENTIFY WITH DART P/N D3472-041 USING FINE POINT PERMANENT INK MARKER
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -041	P/N	DESCRIPTION
X	D3472-041	CABIN HEAT OUTLET DEFLECTOR
1	D3472-1	FLAP
1	D3472-3	HINGE
4	MS20426AD4-4	RIVET

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### **D3472-1 FLAP BENDING DETAIL**

1) MATERIAL: 2024-T3 ALUMINUM SHEET (0.040" THICK)  
PER QQ-A-250/4 OR AMS 4037  
(REF. DART SPEC. M2024T3S.040)

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

3) PART IS SYMMETRICAL ABOUT CENTERLINE

4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

5) ALL DIMENSIONS ARE IN INCHES

6) BREAK ALL SHARP EDGES 0.005 TO 0.010

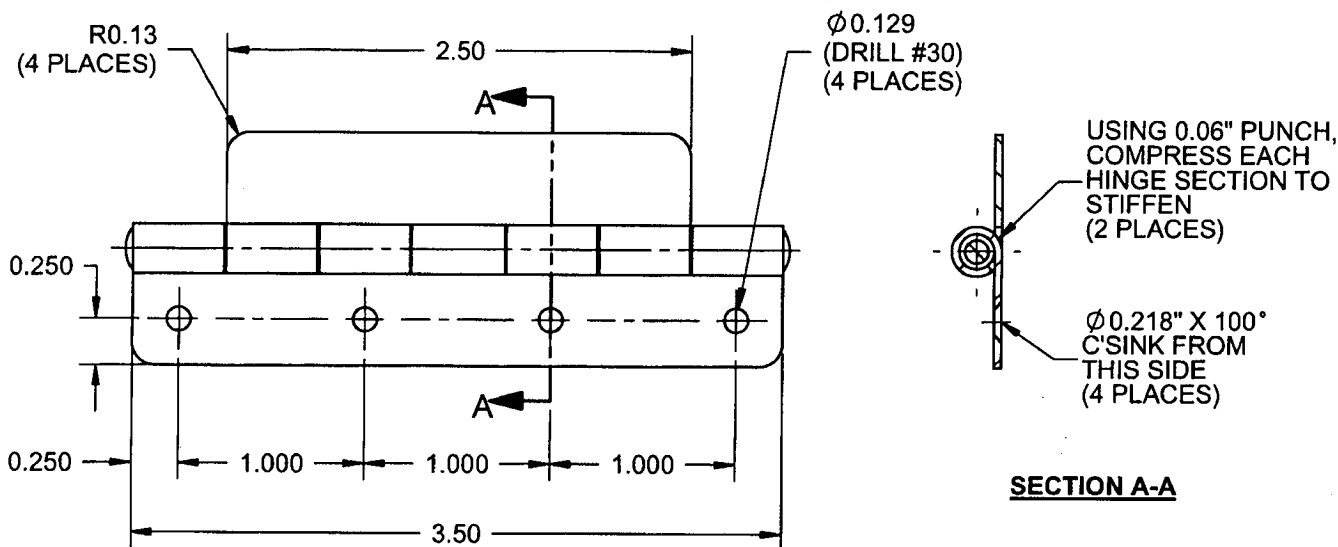
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NO. 3445

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DESIGN #3	DRAWN BY #3	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3472	REV. A SHEET 3 OF 4
DATE 06.01.17		TITLE HEAT OUTLET DEFLECTOR	SCALE 1:1

06.04.07 #



### D3472-3 HINGE

#### NOTES:

- 1) MAKE FROM MS20257-3 HINGE, MODIFIED AS SHOWN
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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WORK ORDER  
NO. 34415

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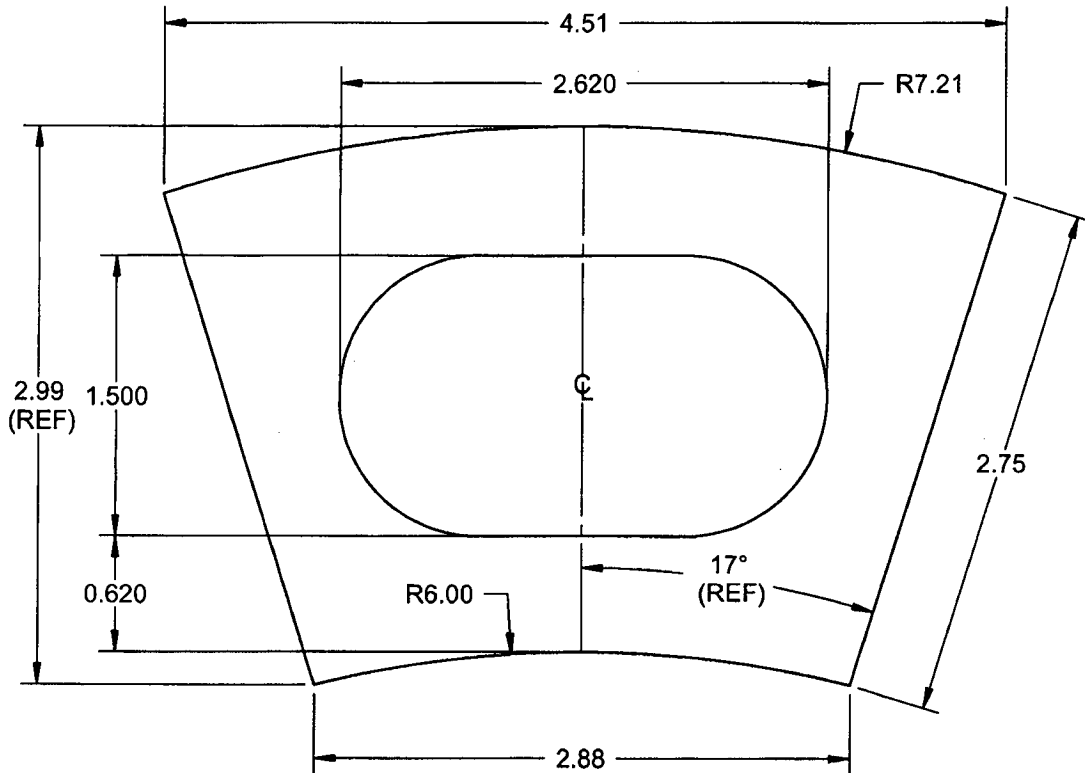
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**DART**

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3472</b>	REV. A SHEET 4 OF 4
DATE <b>06.01.17</b>	TITLE <b>HEAT OUTLET DEFLECTOR</b>		SCALE 1:1

06.04.03 *[Signature]***D3472-5 FLAT DOUBLER****NOTES:**

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET (0.063" THICK)  
PER QQ-A-250/4 OR AMS 4037  
(REF. DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) IDENTIFY WITH DART P/N D3472-5 USING  
FINE POINT PERMANENT INK MARKER
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010

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NO. **34415**

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DART AEROSPACE LTD	Work Order:	34415
Description: Heat outlet Deflector	Part Number:	D34721
Inspection Dwg: D34721 Rev: A		Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**      ☐ **Prototype**

[illegible]

Measured by:	SAD	Audited by:	En	Prototype Approval:	n/a
Date:	02/09/09	Date:	11/02/10	Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	